

Work Order ID: 53772

November 18, 2009 8:37:58-AM



Page 1

Item ID: D350-748-101

Accept



Setup Start



Revision ID: B E 10.01.12

Stop



Item Name: Crosstube Installation, High Fwd

Start Date: 18/11/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 08/12/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: BA

Date: 09-11-18

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

N/A

Rev D

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPPD350-748-101

CHG001

SCRAP

110

0.00



BENDING MACHINE - CROSSTUBES

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

Bend tube as per Dwg D350-748-141 using CNC bender program D350F and Folio FT



10-1-12

120

0.00



QC15- Crosstube Dimensional Check

QC

Memo

0.00

Quality Control

CP 10.01.13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 53772

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Item ID: D350-748-101

Accept



Setup Start



Revision ID: D

Stop



Item Name: Crosstube Installation, High Fwd

Start Date: 18/11/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 08/12/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

130

0.00



Crosstubes

Crosstubes

Memo

0.00

Crosstubes

1-Drill Tube as per Dwg D350-748-141 Using DT8876 A,B & C Drill Jigs,
Set-up drill table as per QSI 010

2-Deburr

3-Engrave Part # and Batch # as per Dwg D350-748-141

4-Remove all marks from tube within limits of D350-748-141

5- Apply a light coat of LPS3 on the interior of tube

Batch: 129956

MB
10-21-08

HVM 10-1-27

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

CHECK 10 DEG HOLES WITH DT8876E (EUROCOPTER CLAMP)

B* is scripper in g

=> 81010122

④

SCRAP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Required Date: 08/12/2009 Req'd Qty: 1.00



Customer:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 Outsource3 Outsource process - Cad plate	Outsource process-Cadplate per QSI017 4.1.9.1 Memo Issue P/O: <u>11282</u> Stress relief at 375° for 5 hours Magnetic Particle Inspect per ASTM E1444 Cadium Plate per AMS-QQ-P-416B, Class 1, Type 2 Embrittle relief at 375° for 8 hours, Chromate Treat Possible Supplier: Southwest United Industries Ensure Certificate of Conformity is attached	0.00 0.00							<u>PS 10-2-01</u> <u>D</u>
160 Packaging Packaging	Receive & Inspect for Damage & Mat'l Certs Memo Ensure certificate of conformity is attached	0.00 0.00							
170 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							

SCRAP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D350-636-101 PAR #: N/A Fault Category: Cross tube NCR: Yes ☒ DQA: / Date: 10-04-21
 Resolution: SCVAP Disposition: SCVAP QA: N/C Closed: _____ Date: _____

NCR: 53772.		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10-04-21	150	x-tube broke during stress relief @ Cndorath. For root cause please see NCR 10-026	<u>ad</u> 10/04/21	Tube is scrap & sent for inspection on NCR 10-026	N/A	<u>/</u> 10-04-21	<u>ad</u> 10/04/21	<u>/</u> 10-04-21

NOTE: Date & initial all entries

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Item ID: D350-748-101

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Revision ID: D

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Item Name: Crosstube Installation, High Fwd

Start Date: 18/11/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 08/12/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 	SprayPaint	0.00							
SprayPaint	Memo	0.00							
Spray Painting	1-Prime inside crosstube as per QSI 005 4.2 2-Prime Outside of Tube as per Dart QSI 005 4.2								
190 	QC14- Inspect Spray Paint	0.00							
QC	Memo	0.00							
Quality Control	Then, Wrap in plastic bag to protect from scratches								
200 	Crosstubes	0.00							
Crosstubes	Memo	0.00							
Crosstubes	1-Install Ground wire Insert, then insert screw and washer 2-Install Abrasion strips as per Dwg D350-748-141 & QSI 035. 3-Install supports Using Dt8876 as per Dwg D350-748-141, Torque to 60-80 IN-LBS								

SCRAP

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Item ID: D350-748-101

Accept



Setup Start



Revision ID: D

Stop



Item Name: Crosstube Installation, High Fwd

Start Date: 18/11/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 08/12/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
220 Packaging Packaging	Pick Kit Memo	0.00 0.00							
230 QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.00							

SCRAP

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Item ID: D350-748-101

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Setup Start



Revision ID: D

Stop



Item Name: Crosstube Installation, High Fwd

Start Date: 18/11/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 08/12/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240		0.00							
	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-748-101								
	Location: _____								
	PPP Rev: _____								
250									
	QC21 - Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

SCRAP

W 10.04.12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 53772

Parent Item: D350-748-101RevD

Parent Item Name: Crosstube Installation, High Fwd

Start Date: 18/11/2009

Required Date: 08/12/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D350-748-101RevD		Manufactured	No			110	Each	4.0000	1.0000			



Crosstube Turning Detail

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FG

37995

37999

40099

40103

1

1

1

1

200

Each

7,324.000 1.0000

ALS4-1032-225

Purchased

No



Insert

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

107441

110768

7324

16

7308

DD

10-1-12

SCRAP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 2

Work Order ID: 53772

Parent Item: D350-748-101RevD

Parent Item Name: Crosstube Installation, High Fwd


Start Date: 18/11/2009

Required Date: 08/12/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD10  Washer		Purchased	No			200	Each	2,402.000	1.0000			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	2402	
105442	19	
109059	2	
109840	23	
110985	202	
111279	5	
111668	64	
112314	965	
112369	122	
113149	1000	

D2856-400RevA

Manufactured

No

200

f

354.0237

1.2432



Abraison Strip

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST403	354.0236842	
50593	144.023684	
52563	210	

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Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 53772

Parent Item: D350-748-101RevD

Parent Item Name: Crosstube Installation, High Fwd



Start Date: 18/11/2009

Required Date: 08/12/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3500-1RevC		Manufactured	No			200	Each	37.0000	4.0000			
												
Saddle												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	37	
47119	12	
47350	5	
52326	20	

D3502-1RevB

Manufactured No

200

Each

83.0000

2.0000



Support

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	5	
41603	2	
42968	2	
47120	1	
Main Warehouse		
ST107	40	
52903	40	
Main Warehouse		
ST168	38	
50287	38	

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item Name: Crosstube Installation, High Fwd

Start Date: 18/11/2009

Required Date: 08/12/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21920-20		Purchased	No			200	Each	135.3000	2.0000			

Clamp (per MIL-DTL-8783C)

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	135.3	
103478	2	
106484	12	
109269	9.3	
110536	10	
111281	2	
112307	50	
112624	39	
112793	11	

MS27039-1-10

Purchased

No

200

Each

212.0000

1.0000

Screw

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	212	
112794	98	
112828	14	
112940	100	

SCRAP

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item Name: Crosstube Installation, High Fwd



Start Date: 18/11/2009

Required Date: 08/12/2009



Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN4-41A 		Purchased	No			220	Each	142.0000	8.0000			
Bolt												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	142	
105940	4	
110363	16	
110731	50	
111424	50	
112082	22	

AN4-6A 		Purchased	No			220	Each	1,765.000	16.0000			
Bolt												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1765	
111279	65	
112314	300	
112641	100	
112720	100	
112829	300	
112933	300	
113149	600	

SCRAPE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Start Date: 18/11/2009

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Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN5-32A		Purchased	No			220	Each	223.0000	4.0000			
												

Bolt

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	223	
106242	3	
106519	4	
110363	17	
112805	49	
112933	50	
113121	100	

AN960JD416

Purchased

No

220

Each

3,001.000

32.0000



Washer

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	3001	
108161	329	
110523	340	
111279	101	
111916	482	
112314	1749	
16941	0	

SCRAP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Start Date: 18/11/2009

Required Date: 08/12/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD516		Purchased	No			220	Each	1,548.000	8.0000			

Washer

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1548	
100564	2	
106167	6	
107534	34	
107959	43	
108246	46	
108672	2	
109059	49	
109752	22	
110363	46	
110523	57	
111279	39	
112082	64	
112314	138	
112828	500	
113149	500	

SCRAPE

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Start Date: 18/11/2009

Required Date: 08/12/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D3501-1RevA		Manufactured	No			220	Each	423.0000	16.0000			
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Bushing

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 423

45402 19

45918 200

48268 204

MS21042L4		Purchased	No			220	Each	4,740.000	24.0000			
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Nut

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 4740

110507 184

111827 4549

112314 7

15924 0

SCRAP

November 18, 2009 8:38:05 AM

Shop Packet Print

Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 9

November 18, 2009 8:38:05 AM

Work Order ID: 53772



Parent Item: D350-748-101RevD



Parent Item Name: Crosstube Installation, High Fwd

Start Date: 18/11/2009

Required Date: 08/12/2009

Comments:

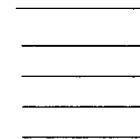
Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L5		Purchased	No			220	Each	854.0000	4.0000			

Nut

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	854	
110382	10	
111127	4	
111636	15	
112314	825	



SCRAP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

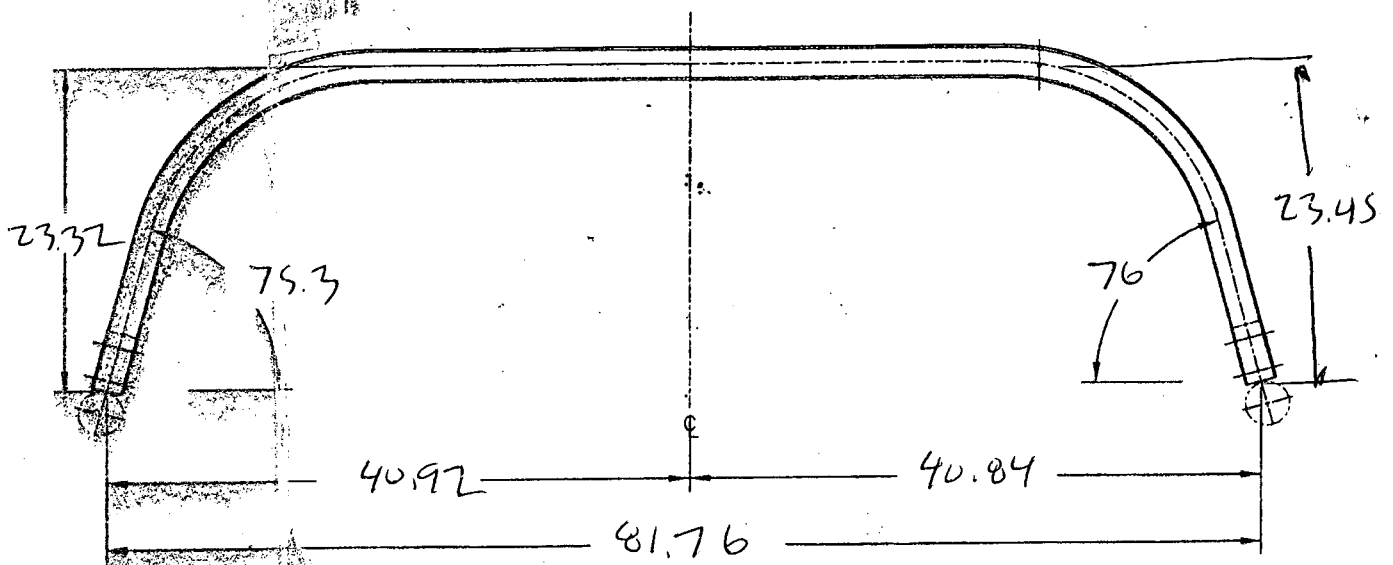
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

PART AEROSPACE LTD		Work Order:	53772
Description: Crosstube High Fwd (AS350/355)		Part Number:	D350-748-101
Inspection Dwg: D350-748-141 Rev: D		Page 1 of 1	

Required Dimension	Min	Max
Height	23.13	23.37
1/2 Span	40.78	41.02
Angle	75	77
Total Span	81.56	82.04



Comments
ONE SIDE HIGH. ACCEPTABLE
TWIST = 0.321"

QC15 Inspection	P
Date	10.01.13

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	[Signature]

Item	Qty	Part Number	Description
1	1	D350-748-141	CROSSTUBE ASSEMBLY (AS 350/355 HI FWD)
2	1	D6017-115	CROSS TUBE
3	2	D3502-1	SUPPORT
4	2	D2856-400-710	ABRASION STRIP
5	1	ASLS-1032-225	INSERT
6	1	NAS1149D0363J	WASHER (OR AN960JD10)
7	2	MS21920-20	CLAMP (PER DART SPEC. M-MS21920-20)
8	1	MS27039-1-10	SCREW

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6017-115
FINISHED LENGTH = 110.270±0.06
- 2) FINISH: MAGNETIC PARTICLE INSPECT PER DART QSI 038 4.2
CADMIUM PLATE PER AMS-QQ-P-416B, CLASS 1, TYPE II
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D350-748-141" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- 7) WEIGHT: 30.45 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE, EXCEPT FOR Ø0.297 HOLE.
- 9) BLEND OUT ALL EDGES FROM MACHINING LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
NOTE: ALL HOLES ARE DRILLED AFTER BENDING.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 7 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 11) HEAT TREAT TO MIN. 180 KSI PER MIL-T-6736 OR AMS 2759-1C AFTER TURNING.
- 12) INSTALL D2856-400-710 ABRASION STRIPS WITH A GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D3502-1 SUPPORT, PER QSI 035.
- 13) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE. WHEN DRILLING HOLES EXTREME CARE MUST BE TAKEN AND CAREFUL DEBURRING PERFORMED TO ENSURE A CLEAN HOLE WITH NO CRACKING/CHIPPING/GROOVES.
- 14) TORQUE CLAMPS 60 TO 80 IN.-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

SHOP COPY
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 33772

BJ 10-4 09-11-18

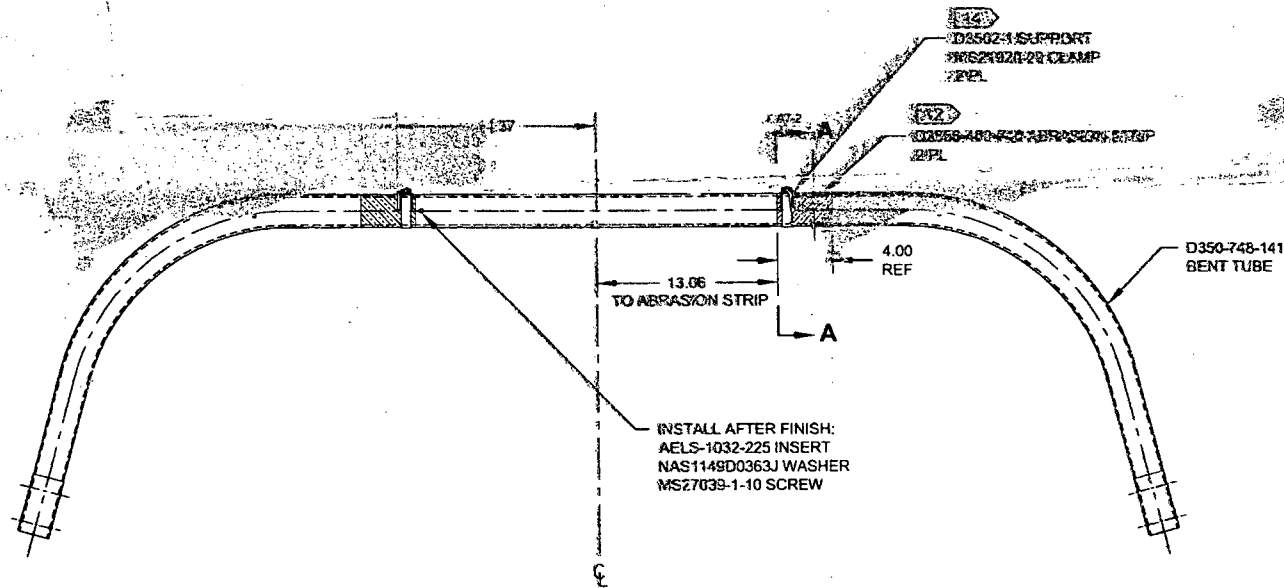
RELEASED
2009-10-29
mp

E	REVISE GENERAL NOTES; UPDATE TO CURRENT ADD STANDARDS; RELOCATED FLAG #6 PER PAR 08-046 (ZN A6-3); TOLERANCES (ZN C6-3, D1-3)	RF	09.09.30
D	MAG. PARTICLE AND CAD PLATE AS MFD.	CP	08.10.31
C	ADD CAD PLATING	CP	06.08.14
B	ADD D6017-115 & PRIME AND PAINT	CP	06.06.30
A	NEW ISSUE	CP	06.03.31
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>q</i>		
DRAWN	RF		
CHECKED	<i>q</i>		
MFG. APPR.	<i>DS</i>		
APPROVED	<i>MP</i>		
DE APPR.	<i>A</i>		
DATE	09.09.30		

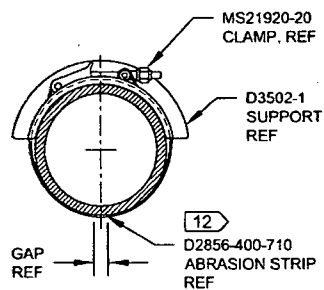
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. E
D350-748-141 SHEET 1 OF 4
TITLE SCALE
CROSSTUBE (AS 350/355 HI FWD) NTS

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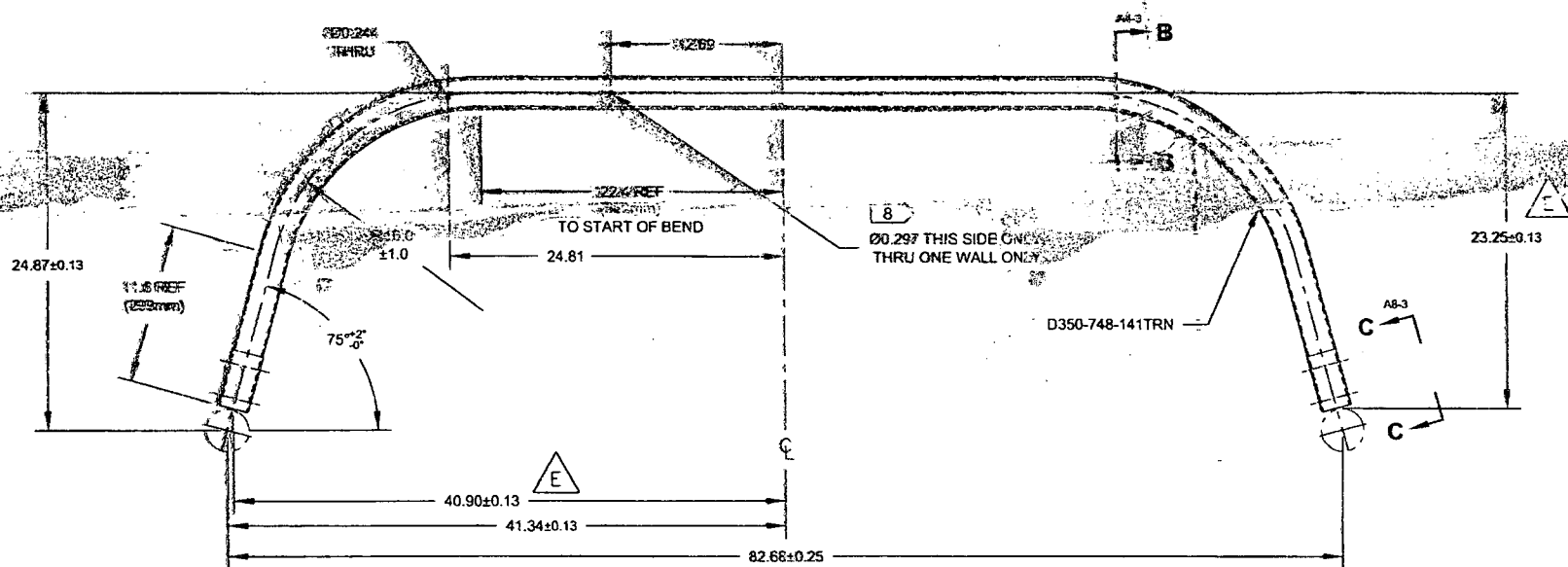
**D350-748-141
ASSEMBLY DETAIL**



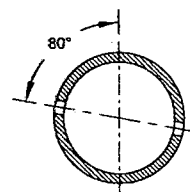
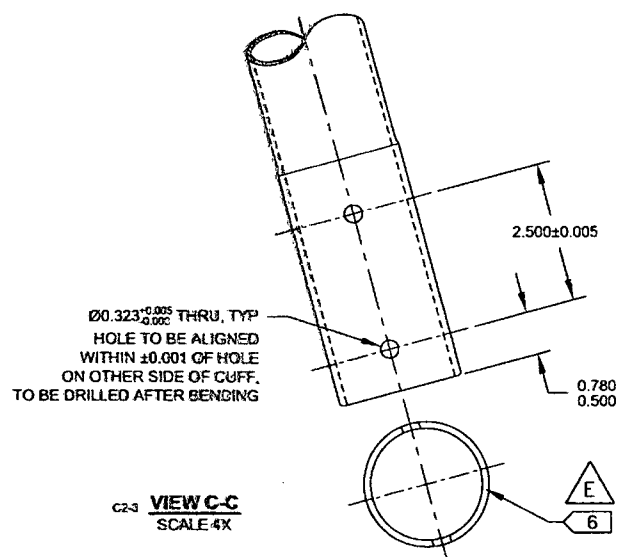
SECTION A-A D4-2
SCALE 4X

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2009-10-29

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CHECKED	90	DRAWING NO.	REV. E
MFG. APPR.	10	D350-748-141	SHEET 2 OF 4
APPROVED	10	TITLE	SCALE
DE APPR.	11	CROSSTUBE (AS 350/355 HI FWD)	NTS
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D350-748-141
BENDING AND DRILLING DETAIL 10

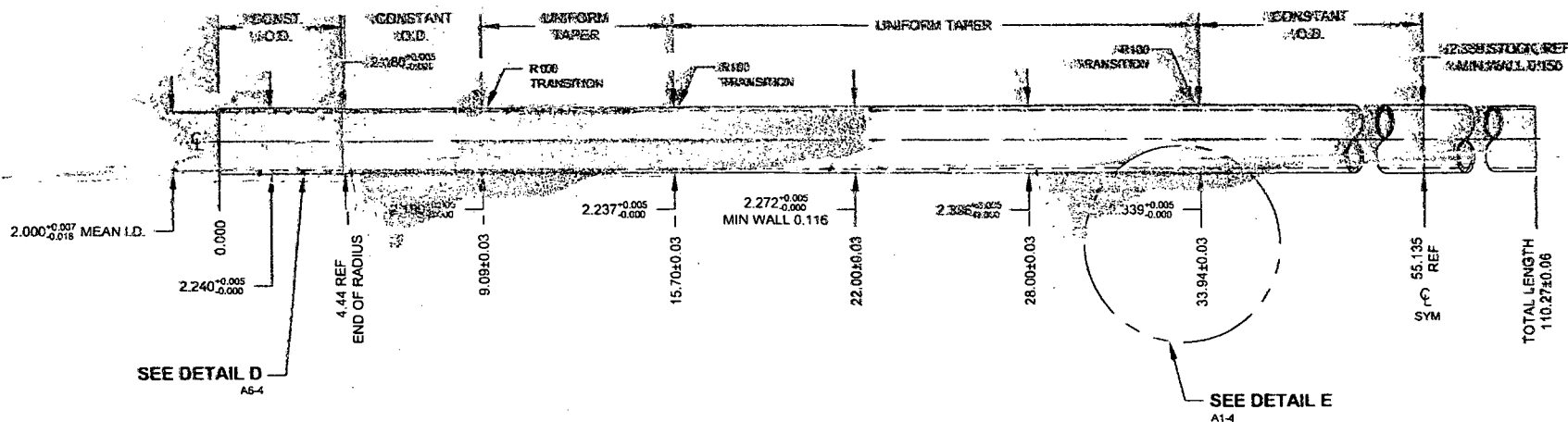


SECTION B-B D3-3
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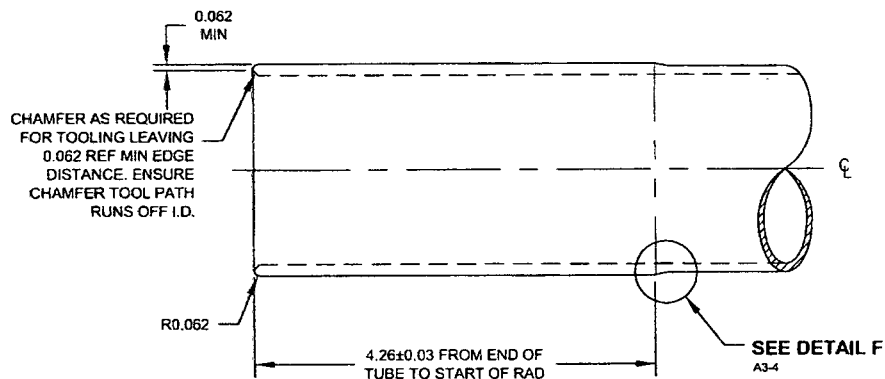
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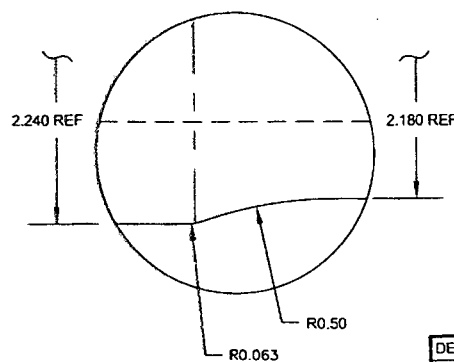
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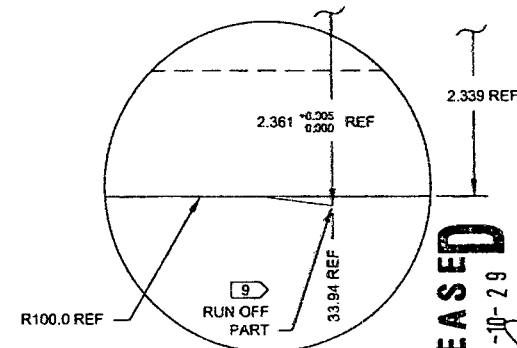
**D350-748-141TRN
TURNING DETAIL**



**DETAIL D:
CROSSTUBE CUFF** C7-4
SCALE 3X



**DETAIL F:
CUFF TRANSITION** A5-4
NOT TO SCALE



**DETAIL E:
TAPER RUN-OFF** C3-4
NOT TO SCALE

DESIGN	40	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	40	DRAWING NO.	REV. E
MFG. APPR.	10	D350-748-141	SHEET 4 OF 4
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